January-25-13 10:23:00 AM

# \*96360\*

Page 1

Item ID: D3027-1 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Clip **Start Date:** 1/25/13 **Start Qty:** 12.00 \*12\* Cust Item ID: Required Date: 2/01/13 Req'd Qty: 12.00 **Customer:** Reference: Run Process Plan: MLJ Date: 13-01-25 Tooling: Approvals: Date: \_\_\_\_\_ Date: \_\_\_\_\_ Stop SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description Run Hours Code Qty Qty Number Stamp **Draw Nbr Revision Nbr** D3027 Rev B 110 0.00 \*110\* Jm13-3-27 Waterjet 0.00 Memo FLOW CNC Waterjet CUT AS PER DWG 2024.063 PROG REV: Grain Direction! **DEBURR** 120 QC2- Inspect parts off machine FAI/FAIB 0.00 \*120\* QC 0.00 Memo Quality Control

### Work Order ID 96360

January-25-13 10:23:00 AM

QC

Quality Control

Memo

\*96360\*

Item ID: D3027-1 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Clip **Start Date:** 1/25/13 **Start Qty: 12.00** \*12\* **Cust Item ID:** Required Date: 2/01/13 Req'd Qty: 12.00 **Customer:** Reference: Run Process Plan: Date: **Approvals:** Tooling: Date: Stop QC: \_\_\_\_\_ Date: \_\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Tool # Plan Set Up/ Tool ID Reject Accept Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 130 QC8- Inspect parts - second check \*130\* QC Memo Quality Control 140 0.00 Small Fab \*140\* Brake NC 0.00 Memo Brake NC FORM AS PER DWG 150 QC5- Inspect part completeness to step on W/O \*150\*

Run

January-25-13 10:23:00 AM

Item ID: **Revision ID:**  D3027-1

Accept

\*N900040100\*

Setup Start

Item Name: **Start Date:** 

Clip 1/25/13

**Start Qty: 12.00** Req'd Qty: 12.00

**Cust Item ID:** 

**Customer:** 

\*96360\*

Reference:

Approvals:

Required Date: 2/01/13

Process Plan: \_\_\_\_ Date: \_\_\_\_ Tooling:

Date:

Date:\_\_\_\_

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID** 

160

Operation Description

Set Up/ **Run Hours** 

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Qty Number

Insp. Stamp

\*160\*

HandFinish

Memo

0.00

0.00

7/6/343

Hand Finishing

170

QC3- Inspect Part Finish

\*170\* OC

Memo

Chemical Conversion Coat per QSI005 4.1

Quality Control

180

Identify as per dwg & Stock Location: \$\int 0.00\$

\*120\*

Packaging

Memo

0.00

Packaging

January-25-13 10:23:00 AM

Item ID: D3027-1 Accept \*N900040100\* Setup Start **Revision ID:** Clip Item Name: **Start Date:** 1/25/13 **Start Qty:** 12.00 **Cust Item ID:** Required Date: 2/01/13 Req'd Qty: 12.00 **Customer:** Reference: Run Process Plan: \_\_\_\_ Date: Approvals: Tooling: Date: \_\_\_\_\_ Stop Date: \_\_\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 190 QC21- Final Inspection - Work Order Release 0.00 \*190\* QC 0.00 Memo Quality Control

M1304-8

### **Picklist Print**

January-25-13 10:23:05 AM

Work Order ID: 96360

\*96360\*

Parent Item:

D3027-1

Parent Item Name: Clip

\*D3027-1\*

**Start Date:** 1/25/13

Required Date: 2/01/13

**Start Qty: 12.00** 

Required Qty: 12.00

**Comments:** 

IPP B01.09.18Now goes on HAASSM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	-
M2024T3S.063		Purchased	No			100	sf	203.8400	0.0277	0.349895	·-··			
*M2024T	35 063*								**	0,4		J	m133:	27

2024-T3 .063 sheet

<b>Location</b>	Loc Qty	Loc Code	
MAT022	203.84		
119916	0.2		
121197	21.34		
123096	11.4		
123654	12.8		123654
123701	158.1		10-01

DART AEROSPACE LTD	Work Order:	96360
Description: Clip	Part Number:	D3027-1
Inspection Dwg: D3027 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Thetatype						
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.800	+/-0.010	2 806"	_		ν	,
1.337	+/-0.010	1.343"	<b>س</b>		ν	
R0.13	+/-0.030	0.13"			RG	
Ø0.098	+0.005/-0.000	0.098"	~		V	
0.310	+/-0.005	6.314	_		V	
0.717	+/-0.005	0.718"	_		V	
0.470	+/-0.005	0.474"	_		V	
						<u>, , , , , , , , , , , , , , , , , , , </u>
						- Andrews

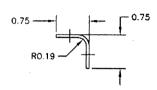
Measured by:	Jm	Audited by:	SMP	Prototype Approval:	N/A
Date:	13-3-27	Date:	15527	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	05.04.26	New Issue	P/O D350-689-013	KJ/JLM	1
В	06.03.09	Dwg Rev upated		KJ/JLM A	ad

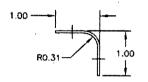


DESIGN DRAWN BY		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KED J	APPROVED 11	DRAWING NO. REV. B
	Alt	-H-	D3027 SHEET 1 OF 2
DATE			TITLE SCALE
05.0	9.20		CLIP 1:2
Α		01.05.18	NEW ISSUE
В		05.09.20	REMOVE HOLES FROM -7

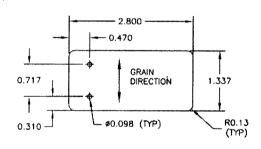




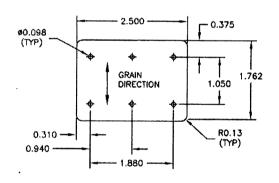
03027-18BEND DETAIL



D3027-3 BEND DETAIL



03027-1 FLAT PATTERN (0.063" SHEET)



D3027-3 FLAT PATTERN (0.050" SHEET)

### NOTES:

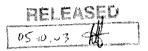
- 1) BREAK ALL UNMARKED SHARP CORNER 0.010 TO 0.020
- 2) MATERIAL: 2024-T3 (QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

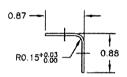
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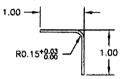


	DESIGN RF	DRAWN BY		ROSPACE LTD (, ONTARIO, CANADA
	CHECKED N	APPROVED AM	DRAWING NO.	REV. B
	H	4H-	D3027	SHEET 2 OF 2
1	DATE		TITLE	SCALE
	05.09.20		CLIP	1:2

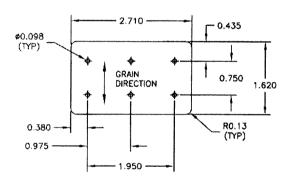




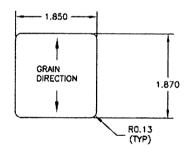
D3027-5 BEND DETAIL



03027-7 BEND DETAIL



03027-5 FLAT PATTERN (0.050" SHEET)



D3027-7 FLAT PATTERN (0.050" SHEET)

#### NOTES:

- 1) BREAK ALL UNMARKED SHARP CORNER 0.010 TO 0.020
- 2) MATERIAL: 2024-T3 (QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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